

Date: Thursday, 5/25/2006 3:37:35 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LATCH PLATE  
 Job Number : 27252  
 Estimate Number : 10511  
 P.O. Number : N/A Part Number : D2621  
 This Issue : 5/25/2006 S.O. No. : N/A Drawing Number : D2621 REV. B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B  
 Previous Run : 25903 Material : N/A  
 Due Date : 6/20/2006 Qty: 40 Um: Each  
 Written By : SEE IN COMMENT BELOW  
 Checked & Approved By : J. 06.05.25  
 Comment : Est: C 02.02.28 Added inspection level 8 and level 5  
 SM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0656 sf(s)/Unit Total : 2.6250 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S040)

Batch: M17835

M 06.05.30

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 4.000" x 2.130"

N/A

J. 06.05.29

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio and Dwg D2621

2- Deburr

Identify as D2621

Water Jet

Dwg Rev B

Prog Rev B

H-M 06/05/31

M 06.05.30 (40)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06.05.30

(40)

5.0

QC8





SECOND CHECK



Comment: SECOND CHECK

Er 06/05/31 40

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)                                                           |                                                                                   |                                  |                |                                                                                                 |                                                                                     |                                                                                                 |
|----------|------|--------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|----------------------------------|----------------|-------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------|
| DATE     | STEP | Description of NC<br>Section A                                                             | Corrective Action Section B                                                       |                                  |                | Verification<br>Section C                                                                       | Approval<br>Design Mgr                                                              | Approval<br>QC Inspector                                                                        |
|          |      |                                                                                            | Initial<br>Design Mgr                                                             | Action Description<br>Design Mgr | Sign &<br>Date |                                                                                                 |                                                                                     |                                                                                                 |
| 06/05/05 | #3   | one (1) Part scrap.<br>MATH Delaminated when cutting<br>out INSIDE Pattern on<br>water St. |  | Scrap and destroy Part.          | En<br>06/05/30 | <br>06-05-31 |  | <br>06-05-30 |
|          |      |                                                                                            |                                                                                   |                                  |                |                                                                                                 |                                                                                     |                                                                                                 |
|          |      |                                                                                            |                                                                                   |                                  |                |                                                                                                 |                                                                                     |                                                                                                 |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/05

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/25/2006 3:37:35 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH PLATE

Job Number: 27252

Part Number: D2621

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/06/01

(40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DL 06/06/01

(40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AL 06/06/01

(40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STS3

AL 06/06/01

(40)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/06/02

(40)

Job Completion



u 06/06/02

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

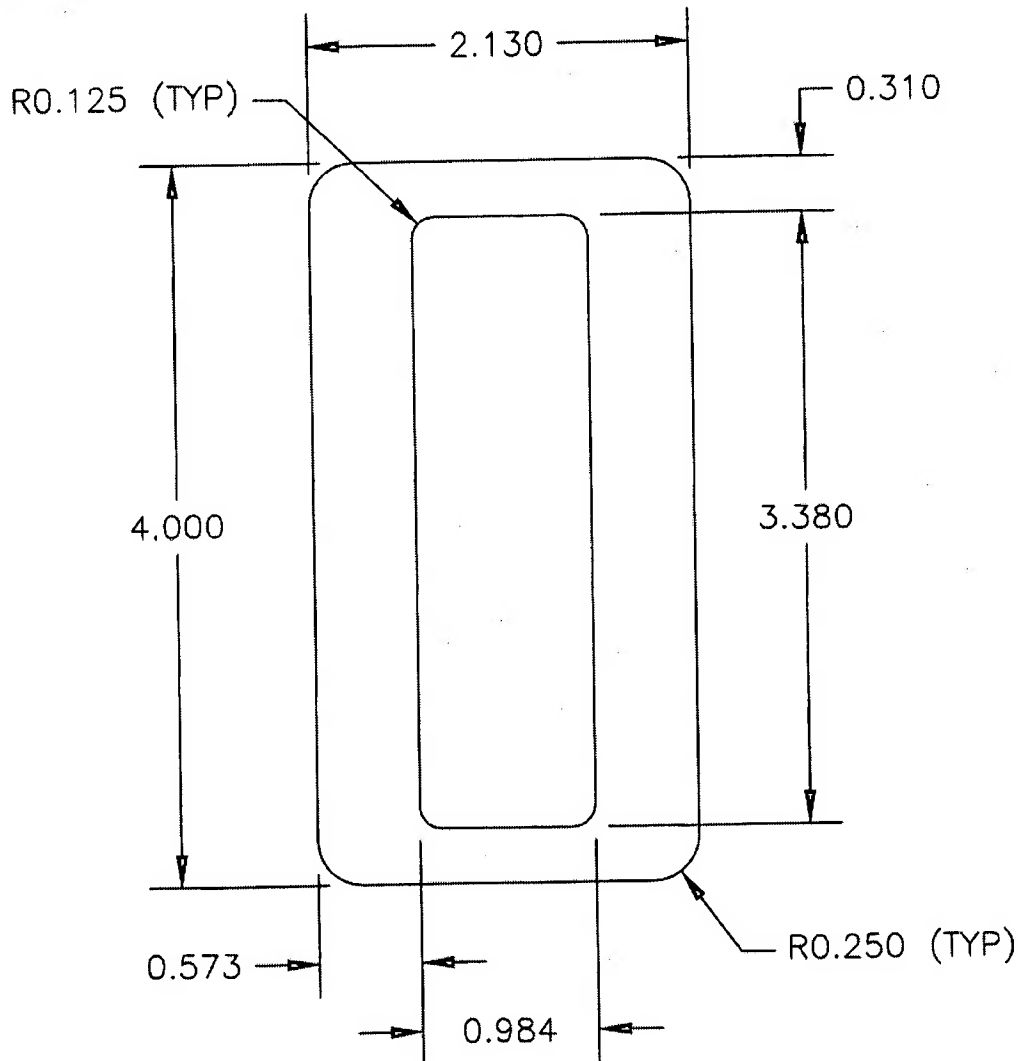
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





|                               |                                |                                                   |                        |
|-------------------------------|--------------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br>RT                 | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2621                              | REV. B<br>SHEET 1 OF 1 |
| DATE<br>00.06.01              |                                | TITLE<br>LATCH PLATE                              | SCALE<br>1:1           |
| A                             | 96.08.15                       | NEW ISSUE                                         |                        |
| B                             | 00.06.01                       | ADDED FINISH; R0.125 WAS R0.118                   |                        |

RELEASED  
00.06.05 *[Signature]*



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3  
(QQ-A-250/4) 0.040 THICK  
FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1  
POWDER COAT BLACK SANTEX (REF. 4.3.5.7) PER DART QSI 4.5  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 27252

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